

SMALL FAB

6122

LRN51

SHIP
713

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW1205G00231-3G

Job Sheet 178273



Part No: RBW1205G00231-3G

Job Qty: 1 ea

Part Name: Main Rotor Damper Oil Filling Adapter



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Part Created: 5/29/18

Job Tracking No:

Due Date: 6/25/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBW1205G00231-3G Rev 2B IPP Rev A 18.02.14m New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/25/18	6/25/18	0.00	0.00	Start Up Small Fab-4		M.L.L.
100	Small Fab	1 pcs	6/25/18	6/25/18	0.25	0.25	Small Fab-9		M.L.L.
110	QC	1 pcs	6/25/18	6/25/18	0.00	0.00	QC5		SA
130	Packaging	1 pcs	6/25/18	6/25/18	0.00	0.00	Packaging3-2		M.L.L.
140	QC21-FG	1 Ea	6/25/18	6/25/18	0.00	0.00	QC21		

Part Op 100 - Assemble as per DWG.
Descriptions: 130 - Identify and Stock

JUL 19 2018

DAS
53
9-89

102 GA

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91611A108	Spring Pin 2mmRND x 18mm	2 Ea (2 ea)	90-Start up Operation	5004183
AN815-6D	Union M Flare	1 Ea (1 ea)	90-Start up Operation	5083000
RBW1205G00231-3G-1	Body	1 Ea (1 ea)	90-Start up Operation	5091800
RBW1205G00231-3G-3	Tube	1 Ea (1 ea)	90-Start up Operation	5063289
RBW1205G00231-3G-5	Pressure Relief Plug (Modified B/O)	1 Ea (1 ea)	90-Start up Operation	5089892
RBW1205G00231-3G-7	Washer	1 Ea (1 ea)	90-Start up Operation	5075932
V75-010	O-ring	2 Ea (2 ea)	90-Start up Operation	5030451
V75-011	Viton 75D Brown O-ring	1 Ea (1 ea)	90-Start up Operation	5038453
V75-013	Viton 75D O-ring	1 Ea (1 ea)	90-Start up Operation	5030452

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	91611A108	2	192	0
	AN815-6D	1	28	0
	RBW1205G00231-3G-1	1	0	0
	RBW1205G00231-3G-3	1	17	0
	RBW1205G00231-3G-5	1	0	0
	RBW1205G00231-3G-7	1	3	0
	V75-010	2	36	0
	V75-011	1	43	0
	V75-013	1	43	0

Part Specifications

Specifications could not be found.



Container No: S093778

Part: RBW1205G00231-3G

Job No: 178273

Serial No/Batch: S093778

Revision: 28

Inspector:

Exp Date:

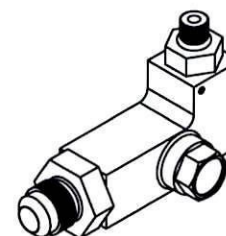
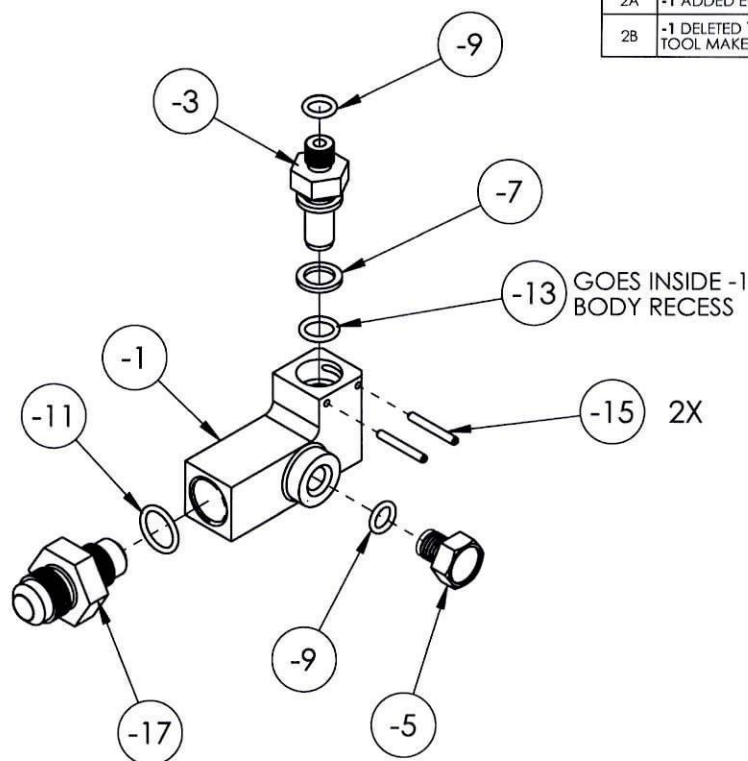
Instructions:

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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/19/18

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED PART -17, -1 REMOVED 7/16-20 THREADED NIPPLE, MOVED RELIEF VALVE .100.	2/24/2011	JAG	
2	-1 CH'D TO USE PORTING TOOL 2 PLACES.	12/20/2011	JAG	
2A	-1 ADDED ENGRAVE NOTE PER S.E.	3/28/2012	RJC	SE
2B	-1 DELETED $\sqrt{\phi .37 \times 90^\circ}$, NEAR SIDE CALLOUT FROM 5/16-24 $\nabla .50$ BECAUSE 5/16-24 PORTING TOOL MAKES THIS FEATURE	1/21/2014	DPD	GE



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WITHOUT NOTICE
WORK ORDER
NO. 178213

20180622

FUNCTION: PART OF HELICOPTER SERVICING KIT T/N 3G1205G00131.
USED IN CONJUNCTION WITH A MANUAL HYDRAULIC OIL PUMP TO
RESTORE THE HYDRAULIC OIL LEVEL INTO THE M/R DAMPER

ORIGINAL No. REF
RBW1205G00231-3G = 3G1205G00231
RBW1205G00213-3G-1 = 3G1205G00651
RBW1205G00231-3G-3 = 3G1205G00551
DO NOT USE, FOR REGERENCE ONLY

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BODY	6061	1-1/8 X 1-3/8 X 2-3/16	2
			-3	1	TUBE	6061	$\phi 3/4 \times 1-1/2$	3
			-5	1	AN PRESSURE RELIEF PLUG	ALUMINUM	AIRCRAFT SPRUCE #AN814-2D (MODIFIED)	4
			-7	1	WASHER	NYLON	$\phi 1/2 \times 3/16$	5
	B/O		-9	2	O-RING	VITON	ID 1/4 X 1/16 WIDTH #V75-010	1
	B/O		-11	1	O-RING	VITON	ID 7/16 X 1/16 WIDTH #V75-013	1
	B/O		-13	1	O-RING	VITON	ID 5/16 X 1/16 WIDTH #V75-011	1
	B/O		-15	2	ROLL PIN	STEEL	$\phi 2mm \times 18mm$ MCMaster-CARR #91611A108	1
	B/O		-17	1	FITTING	ALUMINUM	MS24392D6	1



RED BARN MACHINE

TITLE
MAIN ROTOR DAMPER OIL ADAPTER

DWG NO. RBW1205G00231-3G REV 2B

MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm .005$ FRACTIONS $\pm 1/32$.XX $\pm .01$ ANGLES $\pm 5^\circ$.X $\pm .1$	DRAWN BY: PERRITT
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	APPROVED <i>D Med</i>	REAT TREAT FINISH
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SPEC	USED ON MODEL AGUSTA
SCALE 1:2	DATE 2/23/2011	SHEET 1 OF 5

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					